

Work Order ID 59356-1

Wednesday, June 02, 2010 11:37:48 AM

split -1



MUST SHIP TODAY

Page 1

Item ID: D4127-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Lug

Start Date: 6/2/2010 Start Qty: 4.00



Cust Item ID:

Required Date: 6/2/2010 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals: Process Plan: MP

Date: 10-6-2

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

Draw Nbr

Revision Nbr

D4127

A

100



Waterjet

FLOW CNC Waterjet

Memo

Cut as per Dwg

DWG REV: A

PROG REV: A

DEBURR IF REQUIRED

0.00

0.00

B10-6-2

(6)

110



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

0.00

B10-6-2

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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Customer:

Reference:

Run Start

Approvals: Process Plan:

Date:

Tooling:

Date:

Stop

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

130

0.00



Mill Conv

Conventional Milling Machine

Memo

MILL RADS, DRILL HOLES AS PER DWG
GRIND RAD .060"-.100" BY HAND

0.00

SA 10/06/02

(1)

140



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

0.00

Memo

0.00

SA 10/06/02

(1)

150



QC

Quality Control

QC8- Inspect parts - second check

0.00

Memo

0.00

SA 10/06/02

(1)

Work Order ID 59356

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Page 3

Item ID: D4127-1

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Item Name: Lug

Start Date: 6/2/2010 Start Qty: 4.00



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Required Date: 6/2/2010 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

160

Chemical Conversion Coat per QSI005 4.1

0.00

Hand

10/06/01

x1

0

HandFinish

Memo

0.00

Hand Finishing

170

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

Hand

10/06/01

x1

0

Powdercoat

Memo

0.00

Powder Coating

*MI14207 START: 200pm
Temp: 3200F
Fin: 2:30pm*

180

QC3- Inspect Part Finish

0.00

QC

Memo

0.00

Quality Control

1 BL 10-6-2

Work Order ID 59356

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Page 4

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Accept



Setup Start



Revision ID:

Item Name: Lug

Stop



Start Date: 6/2/2010 Start Qty: 4.00



Required Date: 6/2/2010 Req'd Qty: 4.00



Cust Item ID:

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

210

Identify as per dwg & Stock Location: _____

0.00



Packaging

Memo

0.00

Packaging

ship
11 to
quabec.

220

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/06/02
mr-
10-6-02

W/O:		WORK ORDER CHANGES						
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NOTE: Date & initial all entries

Picklist Print

Wednesday, June 02, 2010 11:37:48 AM

Page 1

Work Order ID: 59356



Parent Item: D4127-1



Parent Item Name: Lug

Comments: IPP REV:A NEW ISSUE 10-05-28 JLM VERIFIED BY:EC

Start Date: 6/2/2010

Required Date: 6/2/2010

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B0.750X06.00 0		Purchased		No			F	44.0800	0.35	1.473684	2,		



6061T6 BAR .750 X 6.00



18 10-6-0

Location

Loc Qty

Loc Code

MAT03

44.08

112567

44.08

112567

W/O:		WORK ORDER CHANGES						
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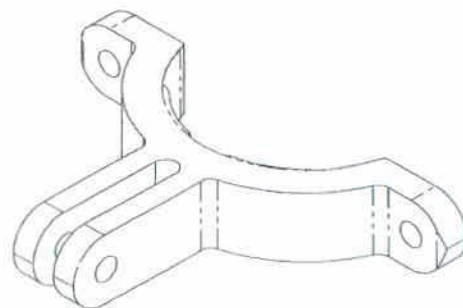
W/O:		WORK ORDER CHANGES						
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D4127-1 LUG

59356

RELEASED
2010-05-28

A	NEW ISSUE	MB	10.05.26
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	10.05.26		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D4127	REV. A
TITLE LUG	SCALE NTS
<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS UNCLASSIFIED AND IS NOT TO BE USED FOR ANY PURPOSE OR REPRODUCED IN ANY FORM OR BY ANY MEANS WITHOUT PERMISSION FROM DART AEROSPACE LTD</small>	

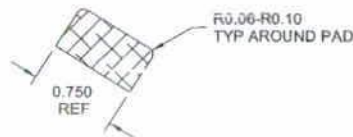
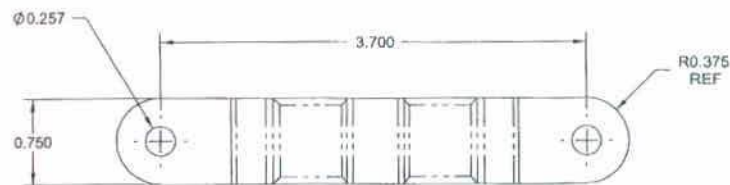
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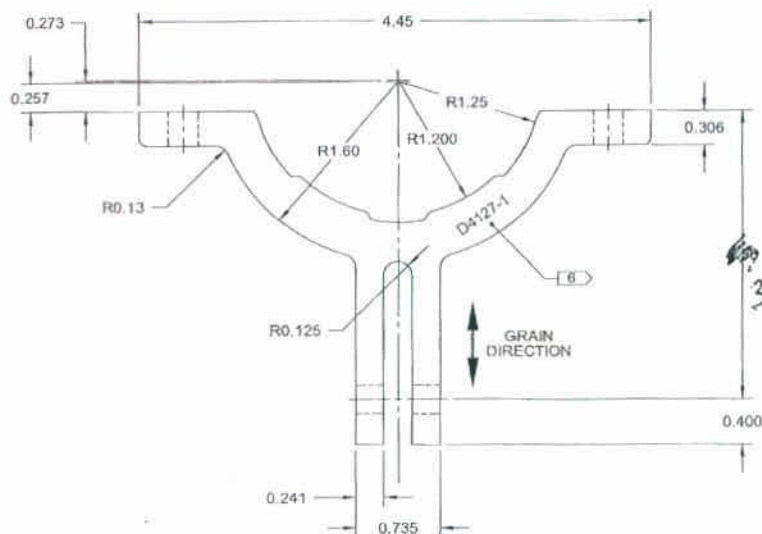
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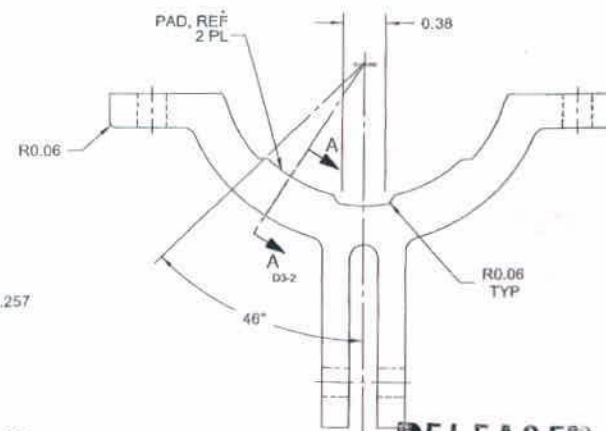
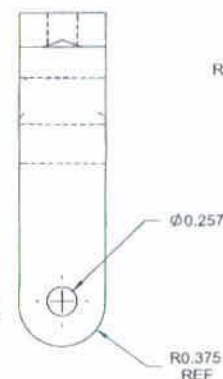


SECTION A-A
SCALE 1X

#59356



D4127-1 LUG



RELEASED
2010-05-28

NOTES:

- 1) MATERIAL: 6061-T6 ALUMINUM SHEET, BAR, OR EXTRUSION
PER QQ-A-200/8, QQ-A-225/8, QQ-A-250/8, ASTM B209, ASTM B211, OR ASTM B221
(REF DART SPEC. M6061T6B, M6061T6S)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE PART NUMBER TO DEPTH OF 0.010±0.005 IN THIS LOCATION,
WITH TOOL A TIP RADIUS OF 0.015±0.005
- 7) WEIGHT: 0.19 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D4127	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		LUG	NTS
DATE	10.05.26	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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Marc Bellavance

From: David Shepherd [dshepherd@dartaero.com]
Sent: June 2, 2010 12:56 PM
To: 'Marc Bellavance'; 'Mike Petsche'; 'Dan Stow'
Subject: RE: Ski basket and step install on AS350 B3

Marc,

This deviation is acceptable to me.
Once the customer has confirmed that the installation works ok, we will change the drawing.
Please make sure he has the new part for tomorrow morning as this is Strike 2.

David

-----Original Message-----

From: Marc Bellavance [mailto:mbellavance@dartaero.com]
Sent: Wednesday, June 02, 2010 10:46 AM
To: 'Mike Petsche'; 'Dan Stow'; 'David Shepherd'
Subject: RE: Ski basket and step install on AS350 B3
Importance: High

David,

Dan talked to Jon who is installing the basket/step for Fred Carrier.
According to him, the lug needs to be 0.50" longer.
So I have hand-changed the 2.56" dimension on Rev. A to 3.06" in order to save time on this.
For posterity, we just need your blessing to ship the part as an acceptable deviation.

Thanks.

Marc

-----Original Message-----

From: Mike Petsche [mailto:mpetsche@dartaero.com]
Sent: June 2, 2010 10:29 AM
To: 'Dan Stow'; 'Marc Bellavance'; 'David Shepherd'
Subject: RE: Ski basket and step install on AS350 B3

He can't cinch it in 3/8"??

-----Original Message-----

From: Dan Stow [mailto:dstow@dartaero.com]
Sent: June 2, 2010 10:29 AM
To: 'Mike Petsche'; 'Marc Bellavance'; 'David Shepherd'
Subject: FW: Ski basket and step install on AS350 B3
Importance: High

Jon is trying to install the short step and he is saying that our new bracket is not long enough. He needs an answer quickly.

Dan Stow
Technical Support
Dart Aerospace Ltd.
dstow@dartaero.com

p:613.632.5200

c:613.676.0992

-----Original Message-----

From: jon.timberwolf@rogers.blackberry.net

[mailto:jon.timberwolf@rogers.blackberry.net]

Sent: June 2, 2010 10:17 AM

To: support@dartaero.com

Subject: Ski basket and step install on AS350 B3

In Quebec City doing some work for Fred Carrier on his B3 and he has a new ski basket to be installed. He has the low step to go on, as the aircraft has ECL squirrel cheeks, he has drawing # DSI 9524 and the corresponding lug, but as you can see in the attached pictures the lug is not long enough. Need a solution fast.

Thanks,

Jon

Timber Wolf Aviation

Cell 613-401-8370

Sent from my BlackBerry device on the Rogers Wireless Network

No virus found in this incoming message.

Checked by AVG - www.avg.com

Version: 9.0.819 / Virus Database: 271.1.1/2911 - Release Date: 06/02/10 05:57:00

No virus found in this incoming message.

Checked by AVG - www.avg.com

Version: 8.5.437 / Virus Database: 271.1.1/2910 - Release Date: 06/02/10 09:57:00